



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

JUL 24 2018

646.9501
Job Sheet 181160



Part No: 646.9501

Job Qty: 1 ea

Part Name: 206A/B/L-Series Cable Cutter System, High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/23/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C IPP REV:A 12.08.28 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Stores/Pkg-1		JUL 31 2018 AUG 15 2018
110	Packaging	1 pcs	8/17/18	8/17/18	0.00	0.00	Packaging1-1		
120	QC	1 pcs	8/17/18	8/17/18	0.00	0.00	QC4		JRB
125	DC	1 pcs	8/17/18	8/17/18	0.00	0.00	DC		AUG 21 2018
130	Packaging	1 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3-1		JRB
140	QC21-FG	1 Ea	8/17/18	8/17/18	0.00	0.00	QC21		AUG 21 2018

Part Op 125 - Photocopy bluefile & type labels per PPP 646.9501
Descriptions: 130 - Identify and pack for shipping as per PPP 646.9501 Location : FG101

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5078331
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5078332
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	506534030
646.9601	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5078332
646.9602	Lower Cutter Assembly High	1 Ea (1 ea)	90-Start up Operation	5078332
646.9810	Deflector	1 Ea (1 ea)	90-Start up Operation	503080
646.9910	Struts	4 Ea (4 ea)	90-Start up Operation	5075012
647.0110	Roof Doubler	1 Ea (1 ea)	90-Start up Operation	5034033
647.0111	Panel	1 Ea (1 ea)	90-Start up Operation	5025822
647.0112	Strut Bracket	8 Ea (8 ea)	90-Start up Operation	5063024
647.0113	Strut Doubler	2 Ea (2 ea)	90-Start up Operation	5037188
647.0114	Clip	1 Ea (1 ea)	90-Start up Operation	5066616
647.0115	Clip	1 Ea (1 ea)	90-Start up Operation	5066617
647.0116	Doubler	2 Ea (2 ea)	90-Start up Operation	5039680
647.0210	Rail	1 Ea (1 ea)	90-Start up Operation	5019449
647.0310	Channel	2 Ea (2 ea)	90-Start up Operation	5031783
647.0410	Tube	1 Ea (1 ea)	90-Start up Operation	5004443
647.1210	Screen	1 Ea (1 ea)	90-Start up Operation	5052489
AN3-10A	Bolt	8 Ea (8 ea)	90-Start up Operation	5089298
AN3-11A	Bolt	8 Ea (8 ea)	90-Start up Operation	5078165
AN3-3A	Bolt	1 Ea (1 ea)	90-Start up Operation	5056400
AN743-13	Bracket	1 pcs (1 ea)	90-Start up Operation	5019324
CCR264SS-3-06	Rivet	8 Ea (8 ea)	90-Start up Operation	50138333-5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____		DISPOSITION Rework ☐ Scrap ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube</td><td>☐</td> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td></td><td></td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>				Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐			Composite	☐	Supplier	☐		
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Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Container No: S097780
Part: 646.9501
Job No: 181160
Serial No/Batch: S097780
 Revision:
 Inspector:
 Exp Date:
 Instructions: FAA STC SR02271LA 09/12/02 T6316 STC SH10-37 Issue 1, EASA ST

Environment	☐	Operator	☐	Bending	☐	BOM/Route	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Offset/Setup	☐	Centre Not Concentric	☐	Broken/Damage/Defect	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Supplier	☐	Cracks	☐	Inspection Incomplete/Unqualified	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Contamination	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Use for Testing	☐	Cuffs	☐	Countersink	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Poor Information	☐	Crushing	☐	Cut Too Short	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Rushing	☐	Heat Treat	☐	Instructions Incomplete/Unclear	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Drill Holes	☐	Mislabeled	☐	Finish	☐
LOA	☐	Process Improvement	☐	Marks/Chatter	☐			Fit/Function	☐	Misread	☐
Substation	☐	Manufacturing Process	☐					Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Past Due	☐	OTHER :							
Misidentified	☐										

CCR264SS3-04	Rivet	12 Ea (12 ea)	90-Start up Operation	5044217
CCR264SS3-2	Rivet, Cherry	4 pcs (4 ea)	90-Start up Operation	5021949
CR3212-4-04	Cherry Rivet ***✓	1 Ea (1 ea)	90-Start up Operation	5045669
CR3212-5-4	Cherry Rivet	8 Ea (8 ea)	90-Start up Operation	5020639
CR3213-4-05	Rivet	26 Ea (26 ea)	90-Start up Operation	5019315
CR3213-4-1	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation	5019423
CR3213-4-2	Cherry Rivet	18 Ea (18 ea)	90-Start up Operation	5027730
CR3213-4-303	Rivet, Cherry	18 Ea (18 ea)	90-Start up Operation	5084889
CR3213-4-4	Rivet, Cherry	19 Ea (19 ea)	90-Start up Operation	5049830
CR3213-4-6	Rivet	20 Ea (20 ea)	90-Start up Operation	508482x175019369X3
MS21042-08	Use Ms21042L08	54 Ea (54 ea)	90-Start up Operation	5044234
MS21042-3	Nut	17 Ea (17 ea)	90-Start up Operation	5027548
MS21047-3	Nut Plate	6 Ea (6 ea)	90-Start up Operation	5020620
MS21059-3	Nut Plate	2 Ea (2 ea)	90-Start up Operation	F123900-3
MS21059L08	Nut	4 Ea (4 ea)	90-Start up Operation	5019317
MS24694-S8	Screw	5 Ea (5 ea)	90-Start up Operation	FM138333
MS27039-08-06	Screw	4 Ea (4 ea)	90-Start up Operation	5006962
MS27039-08-09	Screw	4 Ea (4 ea)	90-Start up Operation	FM138333-50
add # → MS27039-08-11	Screw	43 Ea (43 ea)	90-Start up Operation	FM138336-10
MS27039-08-12	Screw	2 Ea (2 ea)	90-Start up Operation	F124326-1
MS27039-08-13	Screw	6 Ea (6 ea)	90-Start up Operation	5016508
MS27039-1-08	Screw	5 Ea (5 ea)	90-Start up Operation	5020602
MS27039-1-11	Screw	5 Ea (5 ea)	90-Start up Operation	FM138336-83
MS35842-11	Hose Clamp	1 Ea (1 ea)	90-Start up Operation	FM138326-0
NAS1149F0332P	Washer	62 Ea (62 ea)	90-Start up Operation	5071415
add 16' → NAS1149FN832P	Washer	111 Ea (111 ea)	90-Start up Operation	FM138336-9
NAS1835-08	Insert	4 Ea (4 ea)	90-Start up Operation	FM138336-5

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0990	1	18	0
	600.0991	1	18	0
	600.1012	1	23	0
	646.9601	1	0	0
	646.9602	1	12	0
	646.9810	1	10	0
	646.9910	4	9	0
	647.0110	1	8	0
	647.0111	1	8	0
	647.0112	8	76	0
	647.0113	2	21	0
	647.0114	1	66	0
	647.0115	1	61	0
	647.0116	2	25	0
	647.0210	1	4	0
	647.0310	2	10	0
	647.0410	1	4	0
	647.1210	1	21	0
	AN3-10A	8	225	0
	AN3-11A	8	113	0
	AN3-3A	1	522	0
	AN743-13	1	26	0
	CCR264SS-3-06	8	100	0
	CCR264SS3-04	12	106	0
	CCR264SS3-2	4	288	0
	CR3212-4-4	1	290	0
	CR3212-5-4	8	192	0
	CR3213-4-05	26	210	0
	CR3213-4-1	14	156	0
	CR3213-4-2	18	137	0
	CR3213-4-3	18	154	0
	CR3213-4-4	19	433	0
	CR3213-4-6	20	212	0
	MS21042-08	54	1	0
	MS21042-3	17	122	0
	MS21047-3	6	128	0
	MS21059-3	2	322	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

MS21059L08	4	215	0
MS24694-S8	5	249	0
MS27039-08-06	4	317	0
MS27039-08-09	4	187	0
MS27039-08-11	43	1,381	0
MS27039-08-12	2	141	0
MS27039-08-13	6	221	0
MS27039-1-08	5	357	0
MS27039-1-11	5	256	0
MS35842-11	1	42	0
NAS1149F0332P	62	1,299	0
NAS1149FN832P	111	1,074	0
NAS1835-08	4	94	0

Part Specifications

Specifications could not be found.

Plex 7/23/18 12:57 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

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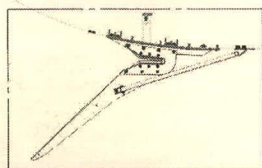
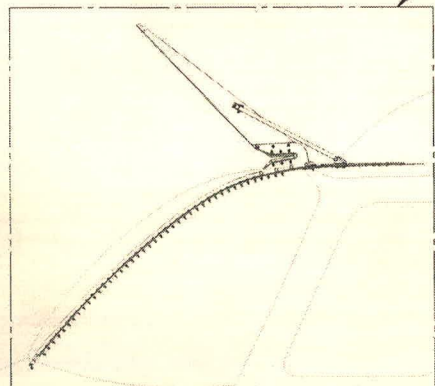
NOTES:

1 AFTER INSTALLATION, APPLY F/N 46 A/R TO FILL GAPS AND FILLET EDGES

UNINCORPORATED ECN(s)

02729, 02736, 03047

AN-10



DETAIL B

QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
1	49	601.1066	RIVET	CR3212-4-4	
1	48	600.0991	MAGNORON 639B PART B		
1	47	600.0990	MAGNORON 639B PART A		
1	46	600.1012	SEALANT	PP-1425 CLASS B	
5	45	601.1949	SCREW	MS27039-1-11	
2	44	601.2989	SCREW	MS27039-0812	
4	43	601.2987	SCREW	MS27039-0802	
4	42	601.3000	SCREW	MS27039-0806	

QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
47	47	41	601.2893	SCREW	MS27039-0811
1	40	601.2982	HOSE CLAMP	MS35042-11	
1	39	647.1210	SCREEN		
5	38	601.1621	SCREW	MS27039-1-08	
14	37	601.2979	RIVET	CR3213-4-1	
4	36	601.2984	INSERT	NAS1835-08	
4	35	601.2277	RIVET	CCR2645-3-09	
8	34	601.2983	RIVET	CR3212-5-4	
12	33	601.2980	NUTPLATE RIVET	CCR2645-3-04	
1	32	601.2822	BOLT	AN3-3A	
1	31	601.2985	BRACKET	AN743-13	
2	30	601.1900	NUTPLATE	MS21059-3	
6	29	601.2988	SCREW	MS27039-0815	
53	28	601.2973	LOCKNUT	MS21042-08	
6	27	600.0795	NUTPLATE	MS21047-3	
18	26	601.0790	RIVET	CR3213-4-3	
18	25	601.1039	RIVET	CR3213-4-2	
19	24	601.1915	RIVET	CR3213-4-4	
20	23	601.2991	RIVET	CR3213-4-6	
26	22	601.1183	RIVET	CR3213-4-5	
4	21	601.2356	NUTPLATE	MS21059-08	
8	20	601.2961	NUTPLATE RIVET	CCR2645-3-06	
17	19	601.2943	LOCKNUT	MS21042-3	
16	18	601.2826	BOLT	ANS-11A	
46	17	601.1607	WASHER	NAS114PP0302P	
114	16	601.2764	WASHER	NAS114PP0302P	
1	15	647.0115	CLIP		
1	14	647.0114	CLIP		
1	13	647.0410	TUBE		
2	12	647.0116	DOUBLER		
1	11	647.0111	PANEL		
2	10	647.0113	STRUT DOUBLER		
8	9	647.0112	STRUT BRACKET		
4	8	646.9910	STRUT		
2	7	647.0310	CHANNEL		
1	6	647.0110	ROOF DOUBLER		
1	5	647.0210	RAIL		
1	4	646.9810	DEFLECTOR		
1	3	646.9603	LOWER CUTTER ASSY LOW		
1	2	646.9602	LOWER CUTTER ASSY HIGH		
1	1	646.9601	UPPER CUTTER ASSY		
		646.9502	206 CABLE CUTTERS KIT LOW		
		646.9501	206 CABLE CUTTERS KIT HIGH		

QTY		NEXT ASSY (S)		ORIGINAL DATE: 06-03-99 DRAWN BY: P. ROSANO CHECKED BY: ID. BARNER DRAWING APPROVAL: 06-03-99 CONTRACT NO.:		PARTS LIST APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 206 CABLE CUTTERS KIT	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE: B CAGE CODE: 07M26 SCALE: NONE		DWG. NO.: 646.9500 SHEET: 1 OF 3		REV. N/C	

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02736		SHEET 1 OF 1	
	DWG NO. 646.9500	REV: N/C	PREPARED BY S. HUFF	DATE: 01/06/10
	EFFECT ON DWG ☐ INC. ☒ UNINC.			
DWG TITLE: 206 CABLE CUTTERS KIT				
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: CORRECTED PARTS LIST ERRORS		

17	R	601.1607	62	62	WASHER	NAS1149F0332P
16	R	601.2764	111	111	WASHER	NAS1149FN832P
			9502	9501		
F/N	TC	PART NUMBER	QTY		DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: ☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM						CHANGE CATEGORY ☐ MAJOR ☒ MINOR
						DER REVIEW REQUIRED ☐ YES ☒ NO

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02729			SHEET 1 OF 3	
	DWG NO. 646.9500	REV: N/C	PREPARED BY S. HUFF	DATE: 12/23/09	EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: 206 CABLE CUTTERS KIT				
	APPROVED BY:	ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: HARDWARE REVISIONS FROM FIRST INSTALL				

51	A	601.3155	8	8	BOLT	AN3-10A
50	A	601.3153	5	5	SCREW	MS24694S8
41	R	601.2893	43	43	SCREW	MS27039-0811
28	R	601.2973	54	54	LOCKNUT	MS21042-08
18	R	601.2826	8	8	BOLT	AN3-11A
16	R	601.2764	127	127	WASHER	NAS1149FN832P
			9502	9501		
F/N	TC	PART NUMBER	QTY		DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:						CHANGE CATEGORY
						DER REVIEW REQUIRED
						☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM ☐ MAJOR ☒ MINOR
						☐ YES ☒ NO

